

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002824**Date Inspected:** 02-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans OBG, Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

**New Tower Bay 1**

The Caltrans QA Inspector randomly observed the milling of weld bevels on three plates, Piece Marks p190A, p190B and p503B.

The Caltrans QA Inspector randomly observed the machine Submerged Arc Welding (SAW) of fill passes on Weld Nos. SSD1-SA180 B/E-23B, 2, and 24. All three welds are on the same weld joint and appear to be numbered as such because the ends are complete joint penetration (CJP) and the center is partial joint penetration (PJP). The welding operator was Xun Chuan jin (I. D. No. 0503060). The welding was in the flat groove (1G) position using Welding Procedure Specification (WPS) Nos. WPS-B-T-2221-B-U3c-S for the CJP; and WPS-B-T-2221-B-P3-S for the PJP. Certified Welding Inspector (CWI), Xu Le feng (CWI No. 07031411) was present during this welding as was ABF QA Inspector, Dai Qing wen. The QA Inspector verified the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm. The minimum preheat and maximum interpass temperatures, voltage, amperage and travel speed were all verified as being within the parameters of the WPS's. The qualifications of the welding operator to perform this welding were also verified.

**New Tower Bay 2**

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## WELDING INSPECTION REPORT

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The Caltrans QA Inspector randomly observed the milling of weld bevel on Piece Mark p1564.

All above observations appeared to meet the requirements of the job specifications.



### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Jobes,Kenneth	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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